

Work Order ID 77100

November-25-11 10:49:40 AM

77100

Page 1

Item ID: D3908-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Plate, Aft Crosstube
 Start Date: 25/11/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 02/12/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3908	C								

100 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet Cut as per dwg D3908
 304 . 475 Prog Rev: E
 Dwg Rev: E
 Deburr as required

11-11-28

20

110 0.00
110
 QC Memo 0.00
 Quality Control

11-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77100

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November-25-11 10:49:40 AM

Item ID: D3908-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Plate, Aft Crosstube

Start Date: 25/11/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 02/12/2011 Req'd Qty: 20.00 ***20*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>11</u>	<u>11</u>	<u>29</u>	<u>(20)</u>
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>90</u> Memo	0.00 0.00				<u>11/11/30</u>	<u>20</u>		
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>11/12/11</u>	<u>20</u>		

C2111/30

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Picklist Print

November-25-11 10:49:45 AM

Page 1

Work Order ID: 77100

77100

Parent Item: D3908-1

D3908-1

Parent Item Name: Lug Plate, Aft Crosstube

Start Date: 25/11/2011

Required Date: 02/12/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A: new issue DD 09.11.17 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per PC1
10.05.27 DD verf:EC IPP Rev:D per ECN10-581 10.05.28
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	93.3000	0.0533	1.122105			
M304S11GA									**				
304/316 0.125 Sheet													

B11-11-28

Location

Loc Qty

Loc Code

MAT020

93.3

119006

41.5

119048

51.8

119048

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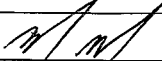
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
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77100
Description: Lug Plate, Aft Crosstube		Part Number:	D3908-1
Inspection Dwg: D3908	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.133	2		✓ B02	
Ø0.191	+0.005/-0.001	.194	2		✓	
Ø0.257	+0.006/-0.001	.261	2		✓	
Ø0.375	+0.006/-0.001	.377	2		✓	
0.310	+/-0.010	.309	2		✓	
0.380	+/-0.010	.380	2		✓	
0.750	+/-0.010	.750	2		✓	
0.469	+/-0.010	.469	2		✓	
3.25	+/-0.030	3.252	2		✓	
0.65	+/-0.030	.648	2		✓	
0.63	+/-0.030	.627	2		✓	
1.587	+/-0.010	1.585	2		✓	
1.588	+/-0.010	1.586	2		✓	
5.46	+/-0.030	5.460	2		✓	
3.80	+/-0.030	3.804	2		✓	
2.13	+/-0.030	2.129	2		✓	
1.313	+/-0.010	1.313	2		✓	
0.375	+/-0.010	.374	2		✓	
0.625	+/-0.010	.624	2		✓	
11.15	+/-0.030	11.149	2		PROWJ02	
0.375	+/-0.010	.375			✓	
0.750	+/-0.010	.754	2		✓	
0.125	+/-0.010	.118	2		✓	

Measured by: B	Audited by: 	Preliminary Approval:
Date: 11-11-28	Date: 11-11-29	Date:

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.04.20	Dimensions updated per Dwg Rev B	KJ	
C	10.06.07	Dimensions updated per Dwg Rev C	KJ 	

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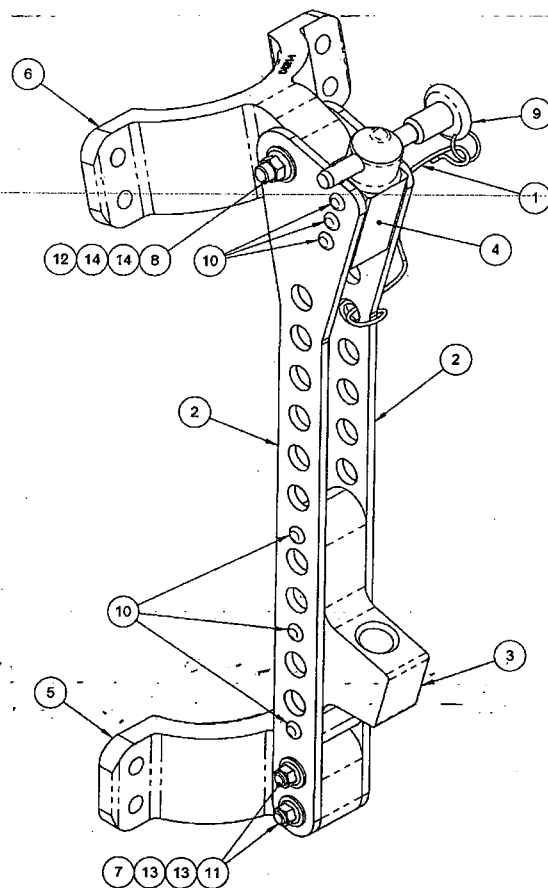
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 97100 M.L.J
11/11/25

RELEASED
2010-05-28
AW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

C	REDESIGNED ITEM #2: ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3909-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413, SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JFH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3908** REV. C
SHEET 1 OF 5
TITLE **X-TUBE LUG ASSY (AFT)** SCALE NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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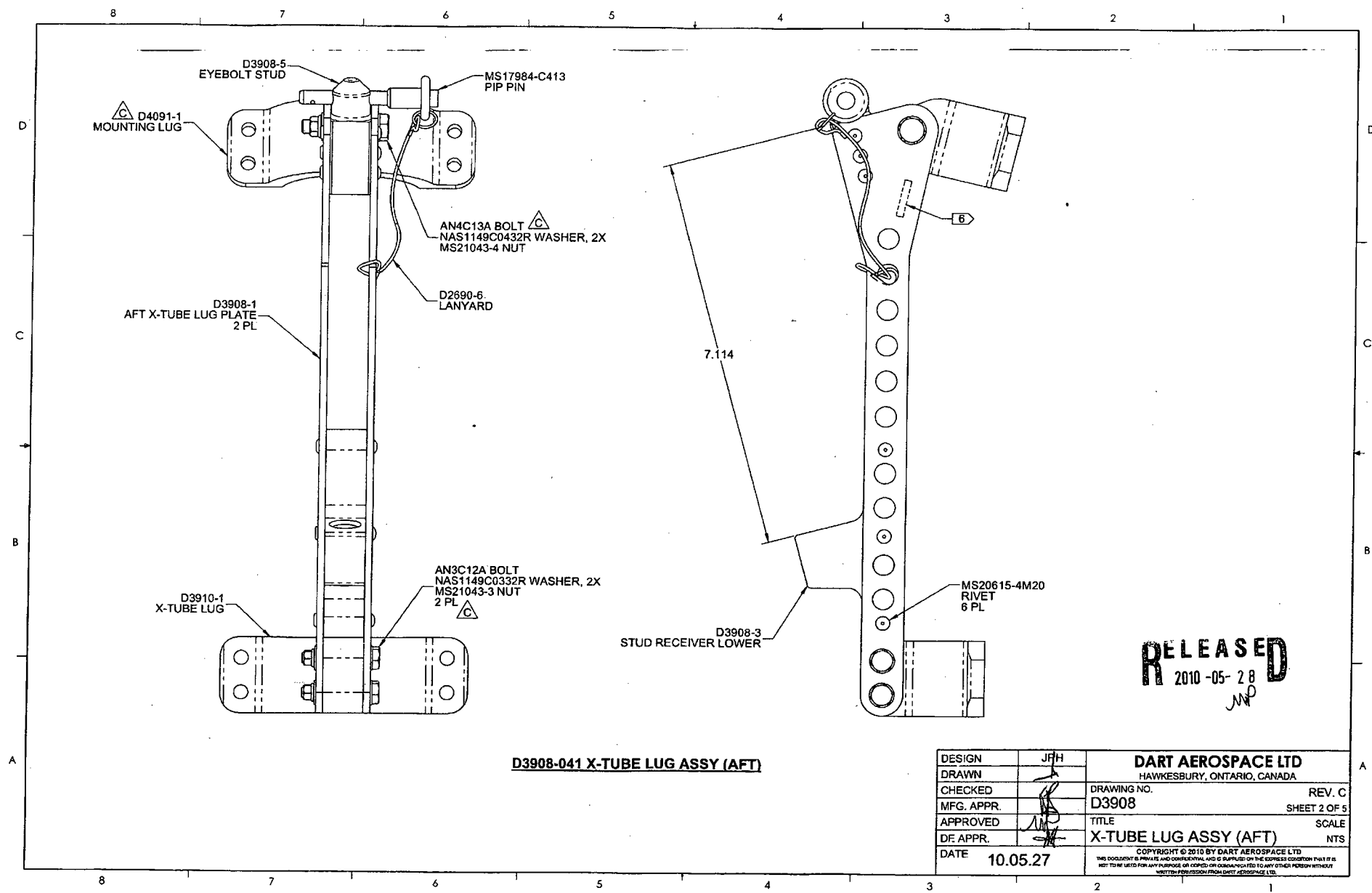
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NOTE: Date & initial all entries

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D3908-041 X-TUBE LUG ASSY (AFT)

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2010-05-28
JMD

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
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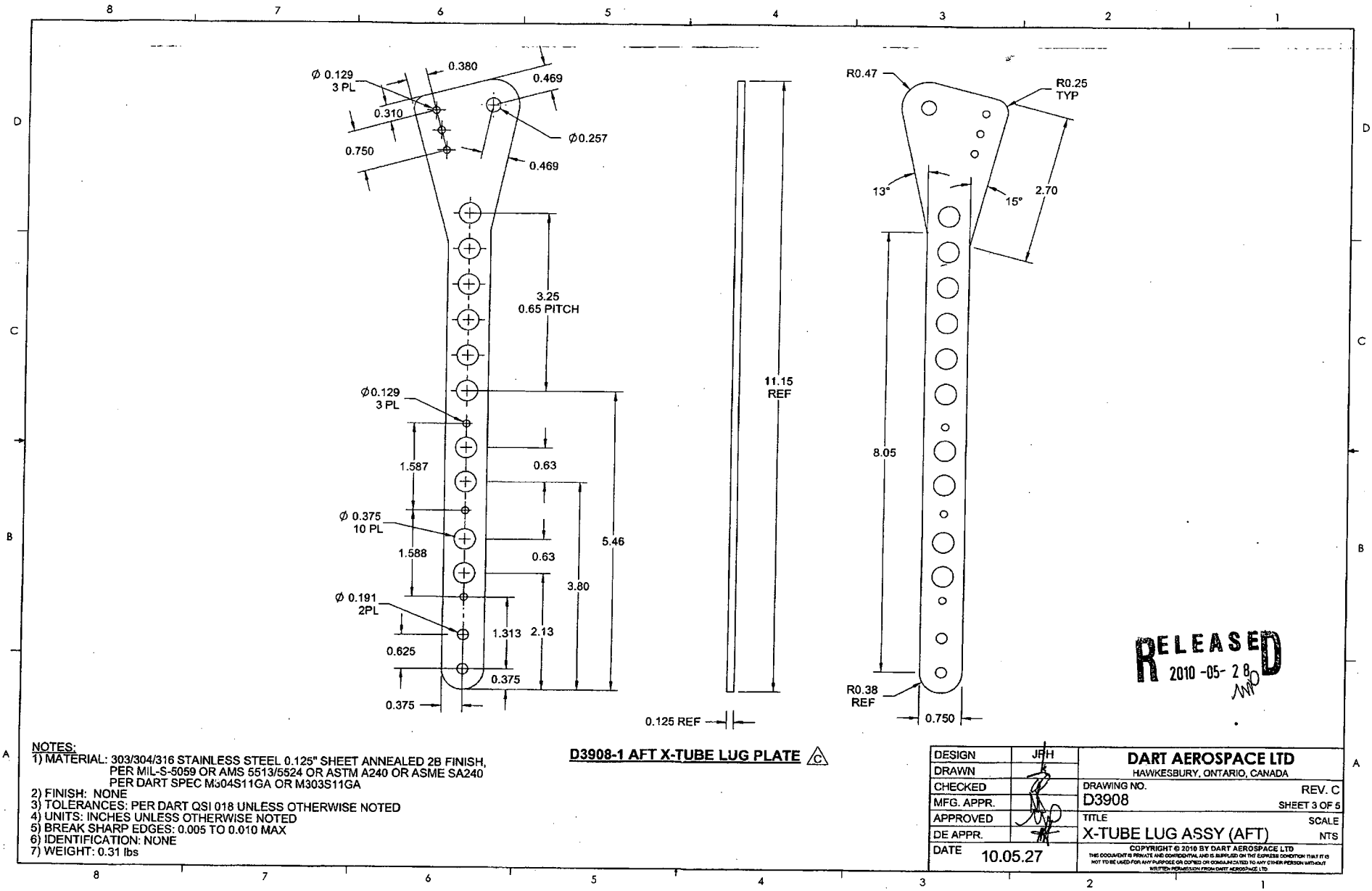
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RELEASED
2010-05-28
AWO

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3908	REV. C
MFG. APPR.		SHEET 3 OF 5	
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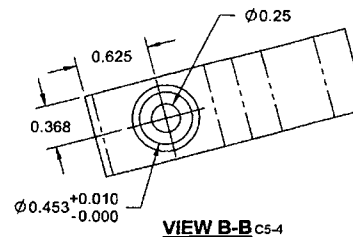
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

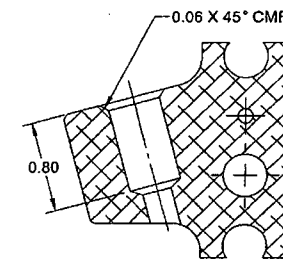
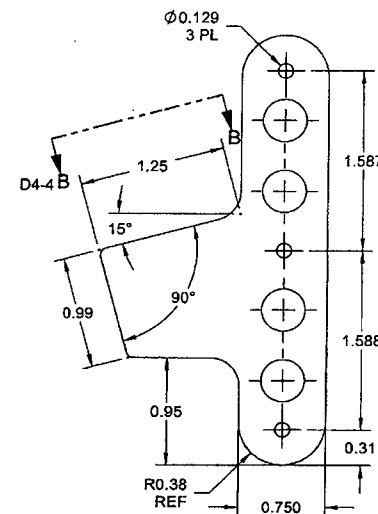
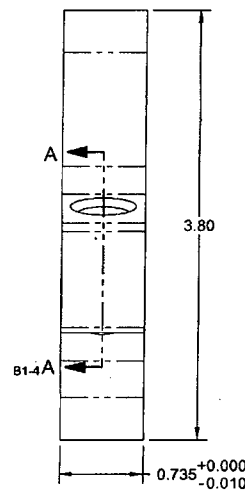
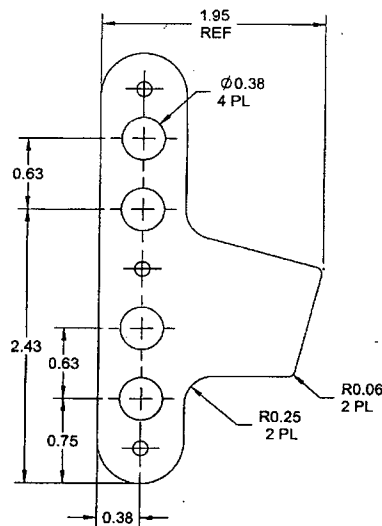
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VIEW B-B CS-4



SECTION A-A B6-4

D3908-3 STUD RECEIVER LOWER

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

RELEASED
2010-05-28

DESIGN	JFH	DART AEROSPACE LTD	REV. C
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3908	SHEET 4 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
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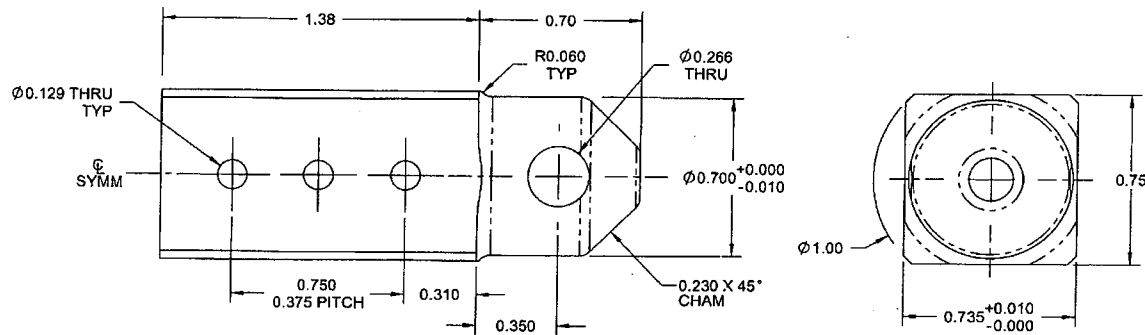
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77100



D3908-5 EYEBOLT STUD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

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